

Date: Friday, 23/01/2009 8:45:37 AM  
 User: Julie Dawson

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WHEEL ASSEMBLY
Job Number	: 45169		
Estimate Number	: 12099		
P.O. Number	:	Part Number	: D3233041
This Issue	: 23/01/2009 S.O. No. :	Drawing Number	: D3233 REV B
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : LARGE FAB ASSY	Drawing Revision	: B
Previous Run	: 45005	Material	:
Written By	:	Due Date	: 06/02/2009 Qty: 10 Um: Each
Checked & Approved By	: <u>JUL 09.01.23</u>		
Comment	: Est. C 05.07.18 * D3233-5 was D3332-5; Qty changed by half K J/JLM		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D32335	Hub Sleeve
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Hub Sleeve

Pick:

Qty Part Number Description Batch B46044 ~~B45376~~1 D3233-5 Hub Sleeve B43416(2) ~~B4325~~

SAD 09-03-25

2.0	D32337	Shaft Sleeve
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Shaft Sleeve

Pick:

Qty Part Number Description Batch

1 D3233-7 Shaft Sleeve B45268

SAD 09-03-25

3.0	D32339	Tire & Rim Assembly
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Tire &amp; Rim Assembly

Pick:

Qty Part Number Description Batch

1 D3233-9 Tire & Rim Assembly B45006

SAD 09-03-25

4.0	NKI 3020	BEARING
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bearing

Pick:

Qty Part Number Description Batch

2 NKI 30/20 Bearing & Inner Sleeve M11065

SAD 09-03-25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 23/01/2009 8:45:37 AM  
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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WHEEL ASSEMBLY

Job Number: 45169

Part Number: D3233041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

SHIM STOCK

.004" Brass Shim Stock



Comment: Qty.: 4.0000 f(s)/Unit Total: 40.0000 f(s)  
.004" Brass Shim Stock

Pick:

Qty Part Number Description

Batch

4 Shim Stock 0.004" thick Brass Shim Stock

M107282

~~M1102136~~

SAD

09-03-25

(10)

6.0

35X45X7

Bearing Seal



Comment: Qty.: 2.0000 Each(s)/Unit Total: 20.0000 Each(s)  
Bearing Seal

Pick:

Qty Part Number Description Batch

2 35x45x7 Axel Seal

or CR 35x45x7 HMS4 R

~~M110615~~

M110615

SAD

09-03-25

(10)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1  
Press out bearings that are supplied with D3233-9 wheel and discard them.

Cut shims and assemble as per Dwg D3233

Spray inside hub and bearing with LPS-3 & block hole with a clean dry rag for storage.

SAD 09-04-14

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 09/04/15

(10)

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA

SAD 09-04-15

(10)

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/16

Job Completion



mf  
09-04-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

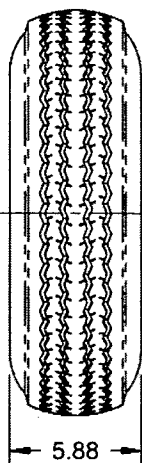
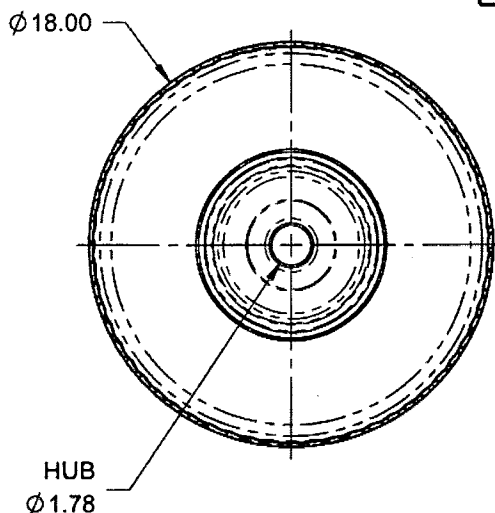
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

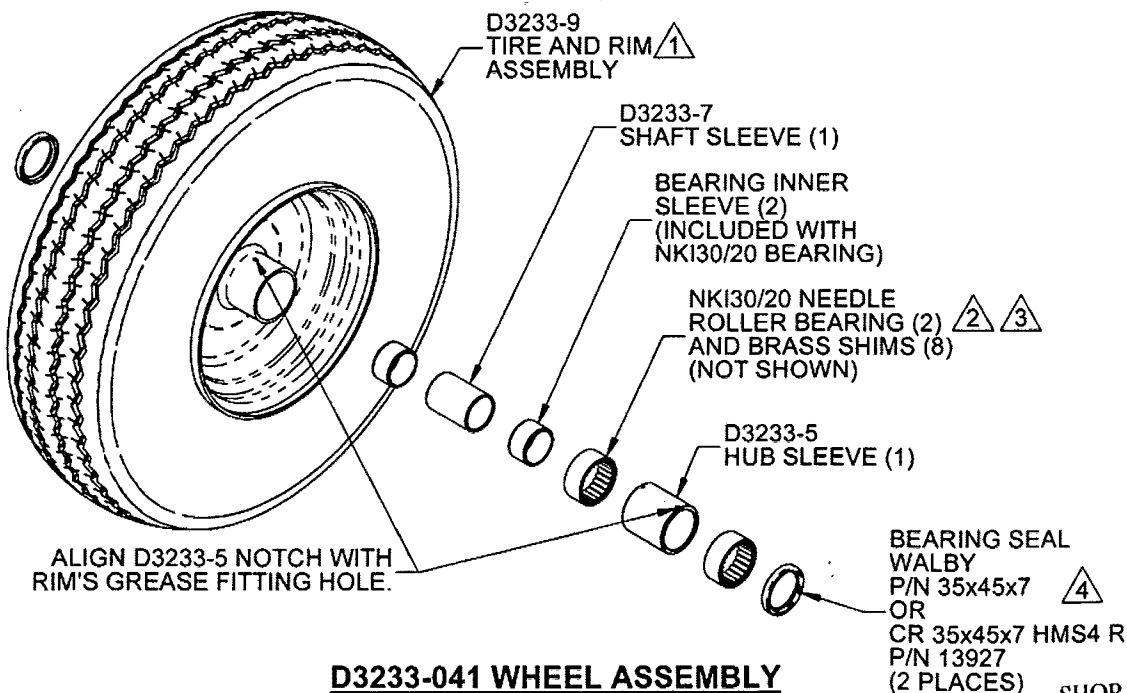
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3233</b>	REV. B SHEET 1 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1
A	05.02.18	NEW ISSUE	
B	05.03.08	ADDED BEARING SEALS	

**RELEASED**  
*[Signature]*  
05/05/04

WHEEL SPECIFICATIONS		
SIZE	MAXIMUM LOAD	MAXIMUM INFLATION LOAD
TIRE: 19.0 x 5.8 RIM: 5.70 x 8.0	910 LBS (RANGE C)	90 PSI*

\* MANUFACTURER'S RECOMMENDATIONS  
ARE 75 PSI FOR HIGH SPEED USE.

**D3233-041 WHEEL ASSEMBLY****NOTES:**

- 1) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 8353T74
- 2) POSSIBLE SUPPLIER: GENERAL BEARING
- 3) PRESS FIT NEEDLE ROLLER BEARINGS INTO RIM HUB WITH (4) 0.5 X 0.75 X 0.004 BRASS SHIMS PER BEARING, (1) AT EACH QUADRANT.
- 4) POSSIBLE SUPPLIER: GENERAL BEARING
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

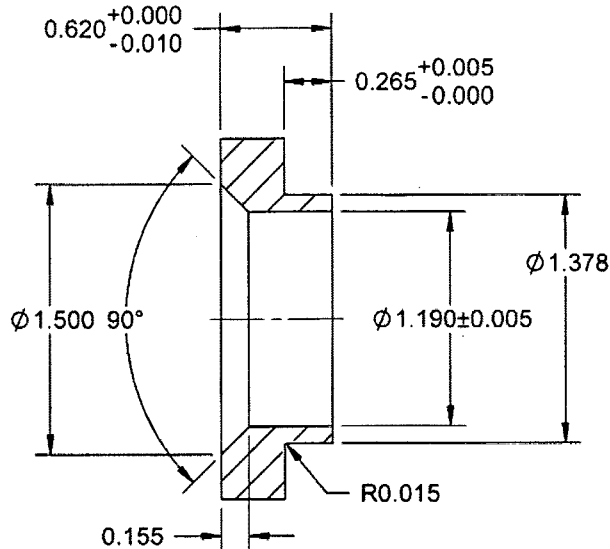
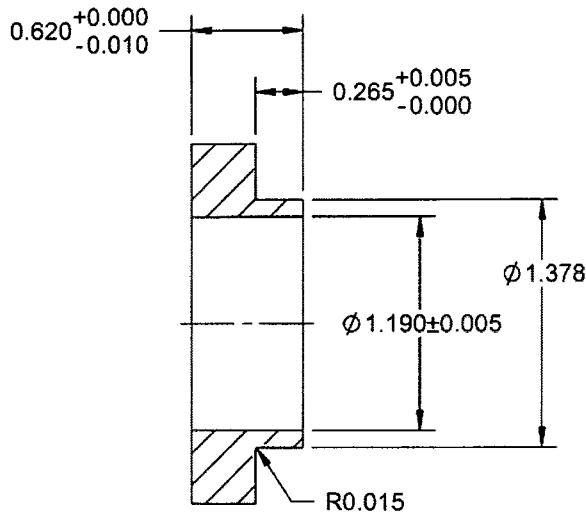
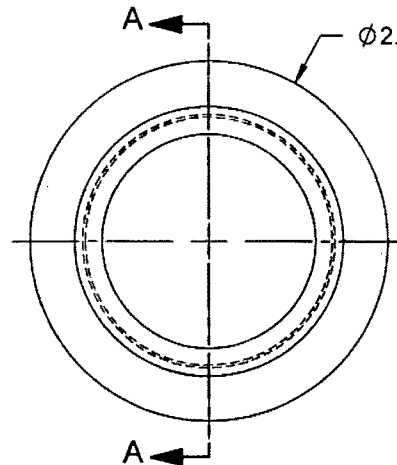
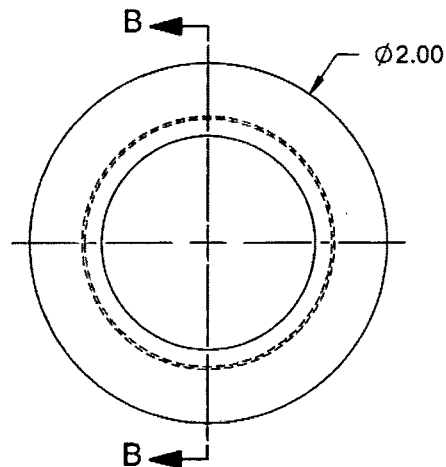
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3233</b>	REV. B SHEET 2 OF 3
DATE <b>05.03.08</b>		TITLE <b>WHEEL ASSEMBLY</b>	SCALE 1:1

**SECTION A-A****D3233-1 INSIDE WASHER****SECTION B-B****D3233-3 OUTSIDE WASHER****NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00 MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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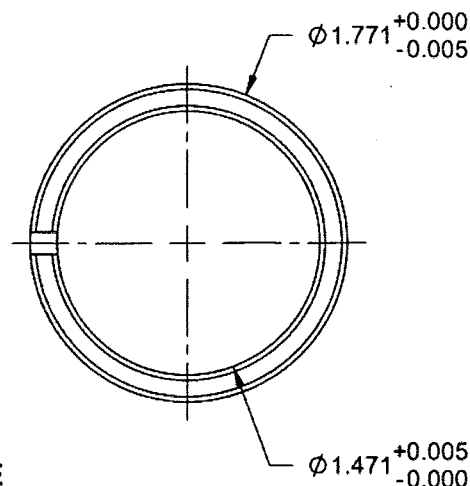
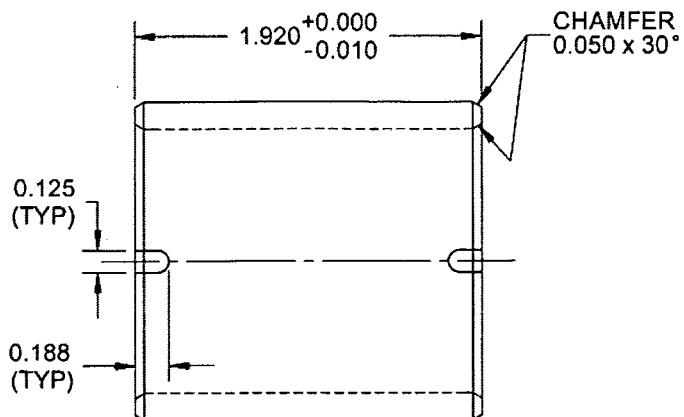
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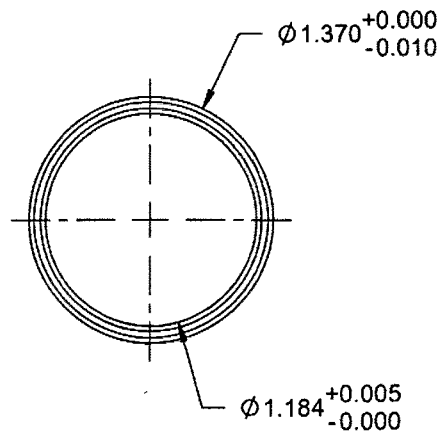
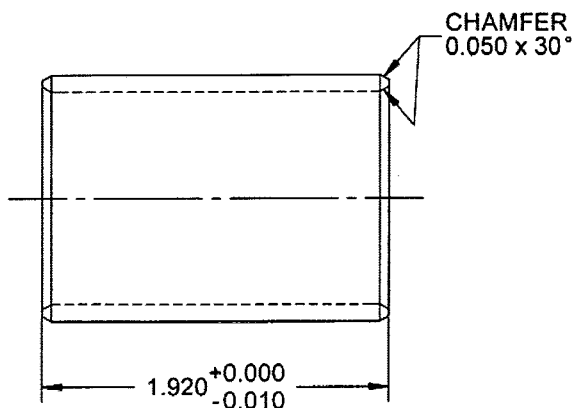


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DATE 05.03.08		TITLE WHEEL ASSEMBLY	SCALE 1:1

RELEASED  
*[Signature]*  
05/05/04



**D3233-5 HUB SLEEVE**



**D3233-7 SHAFT SLEEVE**

**NOTES:**

- 1) MATERIAL: AISI 1020-1025 ROUND TUBING PER MIL-T-5066 OR ASTM A513-00, MT1020 SRA OR AMS 5075 OR AMS 5077, COLD DRAWN, SEAMLESS (REF. DART SPEC. M1020TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.030

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